

Date: Monday, 3/12/2007 10:57:20 AM
 User: Kim Johnston

Process Sheet

As soon as mat'l comes in!

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG BRACKET	
Job Number	: 31160		Part Number	: D30461	
Estimate Number	: 10733		Drawing Number	: D3046 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/12/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: 3/12/2007 Type : SMALL / MED		Due Date	: 3/30/2007	
Previous Run	: 31094		Qty:	29	
Written By	: <u>TD</u> 07.03.12		Um:	30 Each	
Checked & Approved By					
Comment	: Est A 01.08.27 New Issue SM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M174S12GA	17-4 STAINLESS STEEL SHEET
		Comment: Qty.: 0.1260 sf(s)/Unit Total : 3,7800 sf(s) M174S12GA Batch: M103905
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3046 Dwg Rev: B Prog Rev: B
		2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Tumble & deburr Bend as per dwg D3046

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/04/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/12/2007 10:57:20 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 31160

Part Number: D30461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Job 31160 17/29

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: N/A

FC 07/07/19 (29)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(29)

Comment: FINAL INSPECTION/W/O RELEASE

07/07/19 (29)

Job Completion



07/07/19 (29)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31160
Description: Lug Bracket	Part Number:	D3046-1
Inspection Dwg: D3046 Rev: A B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	CP	Prototype Approval:	N/A
Date:	07/04/09	Date:	07/04/09	Date:	N/A

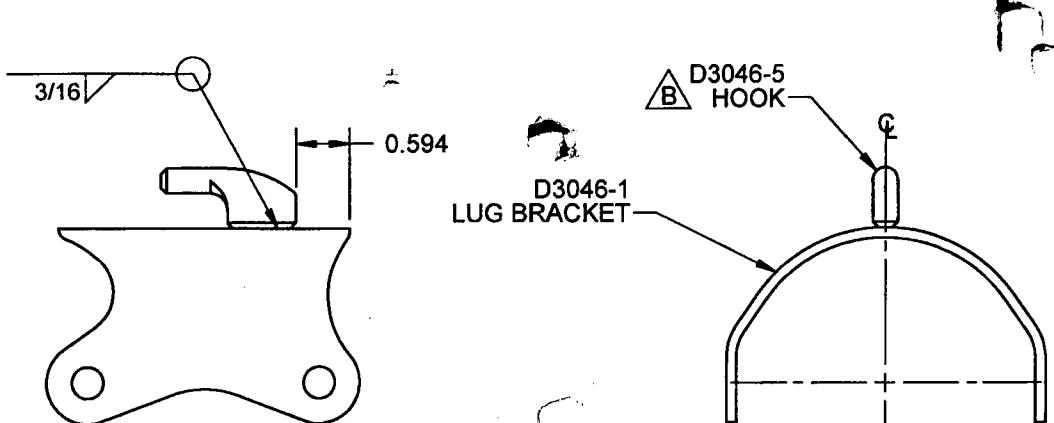
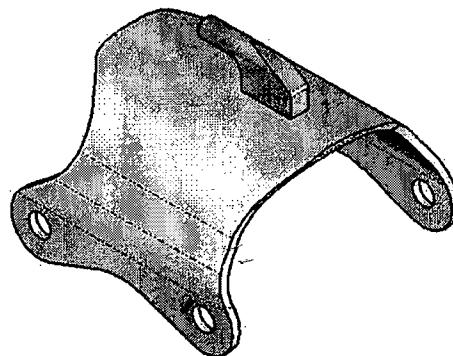
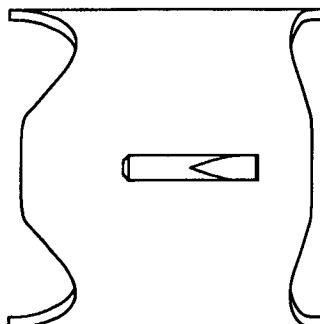
Rev	Date	Change	Revised by	Approved
A	06.09.27	New Issue	KJ/JLM	JLM

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3046
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY	REV. B SHEET 1 OF 3
REV A	DATE 01.08.23	DESCRIPTION NEW ISSUE

RELEASED

06.11.13



D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK

B

NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI)
POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

SHOP COPY
RETURN TO
ENGINEERING

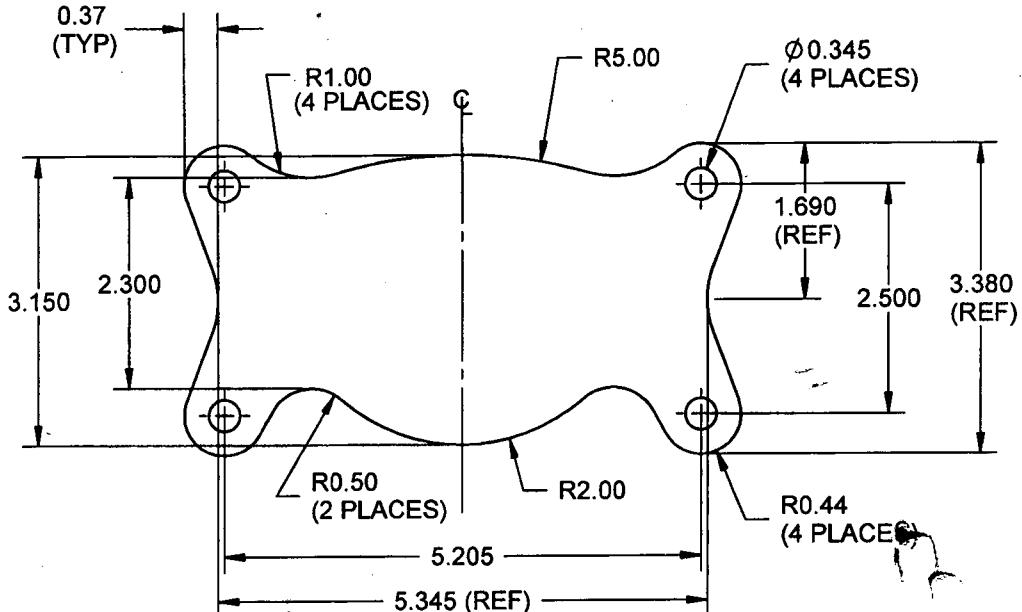
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31160

COPYRIGHT © 2001 BY DART AEROSPACE LTD

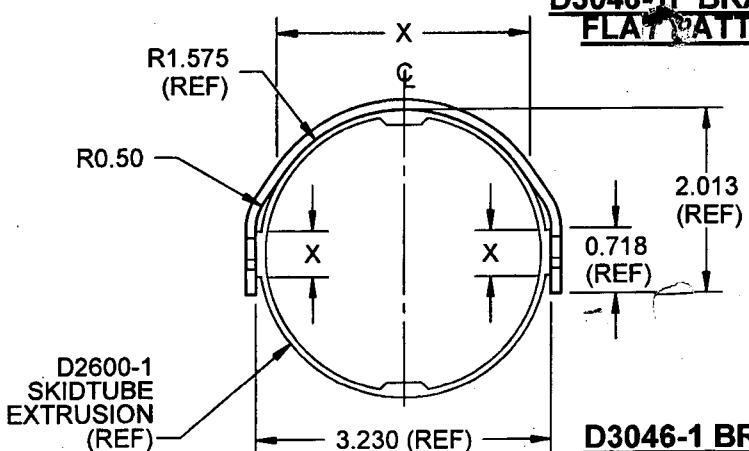
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

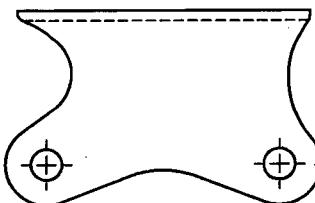
DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3046
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY	REV. B SHEET 2 OF 3 SCALE 1:2



**D3046-1F BRACKET
FLAT PATTERN**



**D3046-1 BRACKET
BEND DETAIL**



RELEASED

06/11/13 *CH*

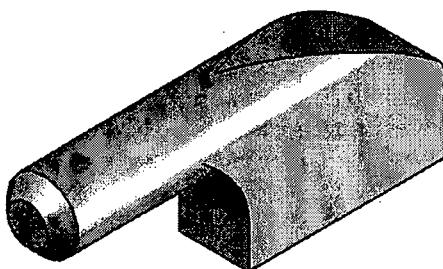
NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.

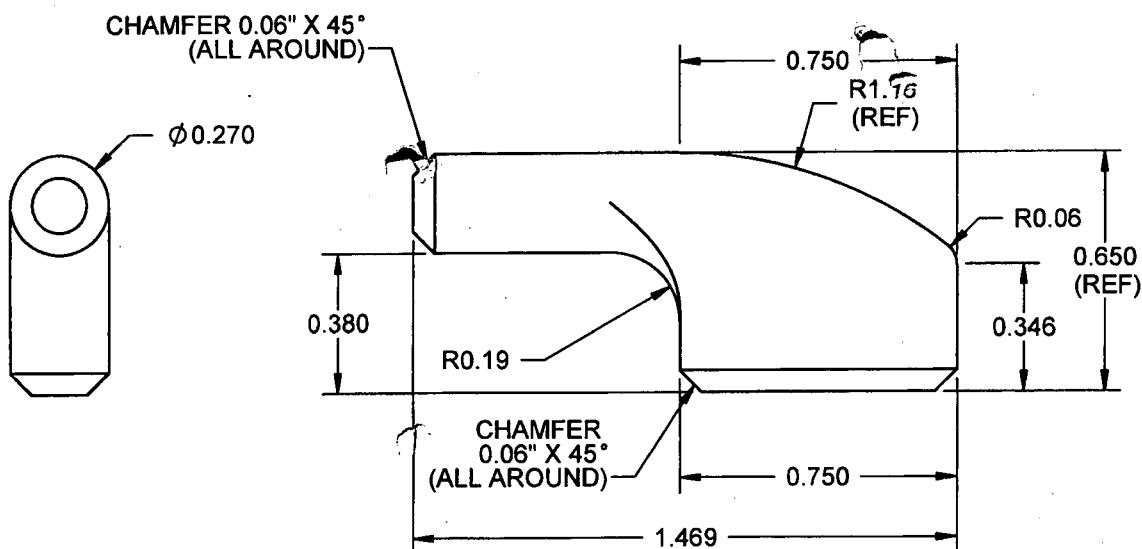
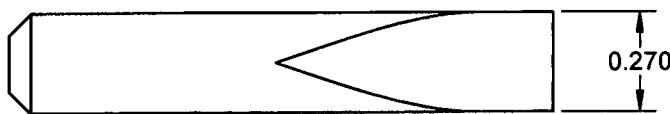
SHOR CRY
RETURN TO
ENGINEERING
UNCONTROLLED COPIES
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31160

DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JLH</i>	APPROVED <i>CH</i>	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26	TITLE LUG BRACKET ASSEMBLY	SCALE 2:1	

**RELEASED**

06-11-13 -

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 ENGINEERING (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED SUBJECT TO AMENDMENT
- 4) ALL DIMENSIONS ARE IN INCHES WITHOUT NOTICE
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX WORK ORDER NO. 31160

SHOP COPY

RETURN TO

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 31160**COPYRIGHT © 2001 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

